

Date: Thursday, 30/10/2008 9:18:31 AM
User: Melanie Fauteux

Process Sheet

DUPLICATE

| | | | |
|-----------------------|--|------------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SQUARE TUBE |
| Job Number | : 41907 - 2 | Part Number | : PB6743001203 |
| Estimate Number | : 13425 | Drawing Number | : B6743001 P.17 |
| P.O. Number | : | Project Number | : N/A |
| This Issue | : 30/10/2008 S.O. No. : | Drawing Revision | : B1 |
| Prsht Rev. | : NC | Material | : |
| First Issue | : 08/09/2008 Type : LARGE FAB ASSY | Due Date | : 26/09/2008 |
| Previous Run | : 41789 | Qty: | 9 Um: Each |
| Written By | : | | |
| Checked & Approved By | : MF 08-10-30 | | |
| Comment | : Est Rev:A 08-06-26 new issue DD verified by:ec | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|------------------------------------|
| 1.0 | M6061T6TS1000W120 | 6061T6 SQ TUBE 1.00 x 1.00 X .120w |



Comment: Qty.: 1.6844 f(s)/Unit Total: 15.1597 f(s)

6061T6 SQ TUBE 1.00 X 0.065 .120" Inf.

batch: M109928

THIS W/O ONLY 10/03/03

| | | |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.050" chamfer on both ends of tube
- 3- deburr

DIP 08/11/13

(21)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

cutter
S 08/11/13 (21)

| | | |
|-----|---------------|------------------------------|
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

- 1- drill holes as per dwg
- 2- make a 0.050" chamfer (100 degree) on both side of the 2 holes
- 3- deburr

DIP 08/11/13

(21)

| | | |
|-----|-----|------------------------------|
| 5.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

cutter
S 08/11/13 (21)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 30/10/2008 9:18:31 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 41907

Part Number: PB6743001203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001227

Bushing



Cpl 08-11-25



Comment: Qty.: 2.0000 Each(s)/Unit Total: 18.0000 Each(s)

Bushing

batch:

~~419116~~ ✓

~~B4100273~~ ✓

B 43712 → 18 ✓

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(x9)

Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

Cpl 08-11-25

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(x9)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

Cpl 08-11-25

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/11/26

(9)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/26 (x9)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *438*

8/11/26

SP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



MF 08-11-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

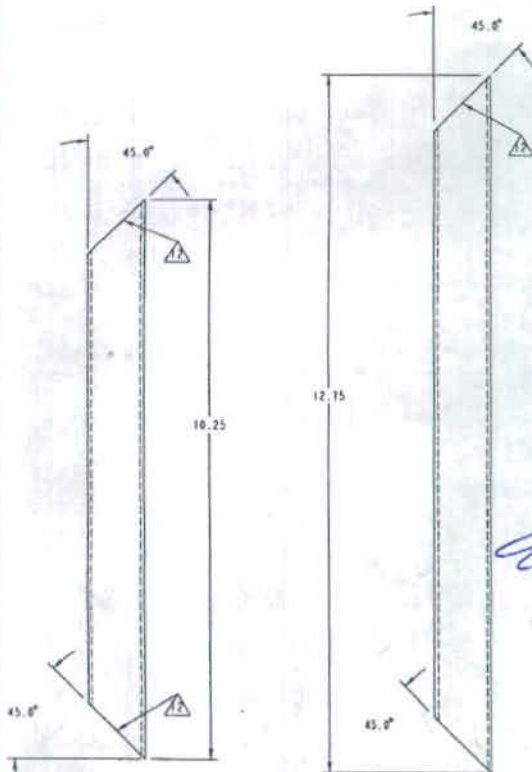
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

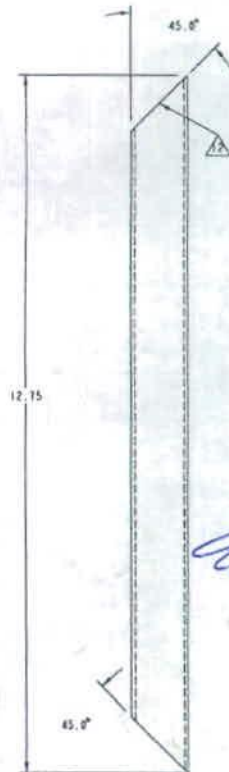
NOTE: Date & initial all entries

RELEASED
#00 01-20

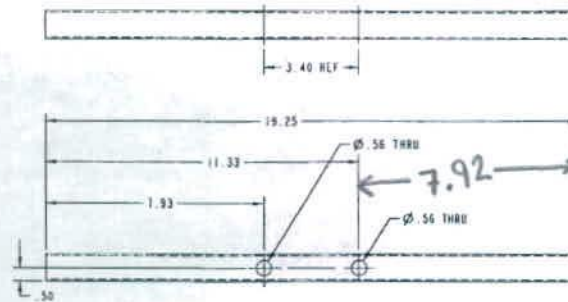
REPLACED BY
SUPERCEDED BY
D-5440-15



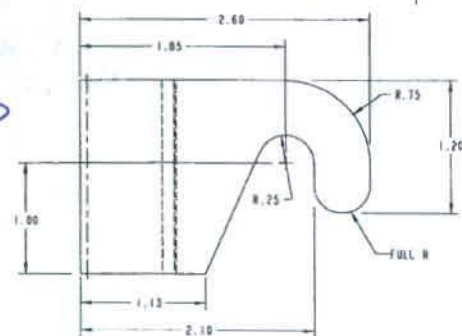
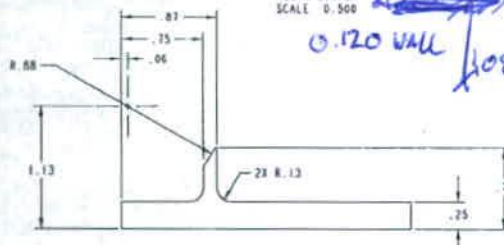
-209 SQUARE TUBE
MATL: 1.00 50 X .005 WALL, 6061-T6
QD-A-200/8
SCALE 1.000



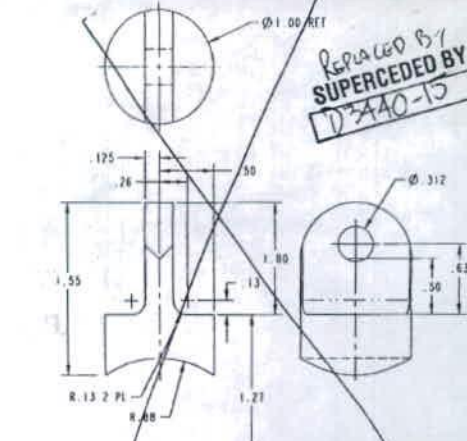
-211 SQUARE TUBE
MATL: 1.00 50 X .005 WALL, 6061-T6
QD-A-200/8
SCALE 1.000



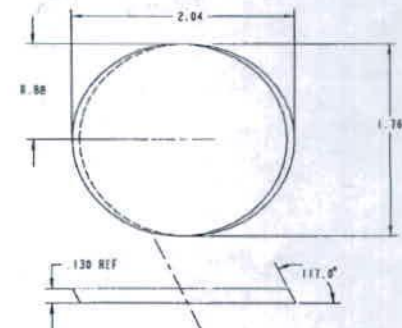
② -203 SQUARE TUBE
MATL: 1.00 50 X .005 WALL, 6061-T6
QD-A-200/8
SCALE 0.500



② -213 FLANGED HOOK
MATL: 6061-T6 QD-A-200/8
SCALE 2.000



① -215 CONTOURED MALE EYE
MATL: 1.00 RND, 6061-T6
QD-A-200/8
SCALE 2.000



-199 OUTER TUBE END CAP
MATL: .125 THK, 6061-T6
QD-A-250/11
SCALE 2.000

PREMIER AVIATION, INC.
1000 Aviation Parkway, Grand Prairie, Texas 75052
DLSUV8 B67-43001 81
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ORIGINAL

